

Work Order ID 84924

\*84924\*

Page 1

May-29-12 2:51:23 PM

Item ID: D209-669-043

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 32/05/29

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2906

Rev B

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002

003 per RCN 12-599 h

N/A

110

0.00

\*110\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

-Open holes to 0.500" as per Dwg D2906 without cutting fluid

-Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

> CF 12-6-18

SAD 12-06-18

76 12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84924

**\*84924\***

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May-29-12 2:51:23 PM

Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop

**\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC3- Inspect Part Finish

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*[Signature]* 12-6-18

130

Skidtubes

0.00

**\*130\***

Skidtubes

Memo

0.00

Skidtubes

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date: 13-4-12

Start Time: 15:45 Date: 12-6-18

Fin Time: 8:00 Date: 12-07-05

pick:

Qty

P/N

description

P/N

1

D2926-3

Web

84949

*CF/* 12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 84924

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**\*84924\***

Page 3

Item ID: D209-669-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 29/05/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 16/07/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	BENDING MACHINE - CROSSTUBES	0.00							
<b>*140*</b>									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150	Skidtubes	0.00							
<b>*150*</b>									
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.								
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

7 DC 12/06/19

→ CF 12-6-19  
 CF 12-7-4  
 BE 12/07/05

1 0 BE 12/07/05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Item Name: Replacement Skidtube

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Start Date: 29/05/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00

**\*170\***

Large Fab

Skidtubes

**Memo**

0.00

Skidtubes

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Debur

-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Debur

-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Debur

SAD 12-07-05

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

QC

**Memo**

0.00

Quality Control

51267105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop

**\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

Pressure Wash per QSI005 4.3

0.00

**\*200\***

HandFinish

Memo

0.00

Hand Finishing

1 7/6/12-7-5

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*210\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30  
320°F  
4:00

IX 12/6/05

220

QC3- Inspect Part Finish

0.00

**\*220\***

QC

Memo

0.00

Quality Control

IX 12/6/06

12/2/841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 11/21/30

Sikaflex expire date: 11/03

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 11/21/30

Sikaflex expire date: 11/6

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: 112220

1x 6 11/03/09

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 7

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

250

Packaging

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-043

Location:

PPP Rev:

PPD 84891

260

QC21- Final Inspection - Work Order Release

0.00

**\*260\***

QC

Memo

0.00

Quality Control

*12/7/12 C*

*12/7/18 J*

*MF 12-07-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 84924

**\*84924\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 <b>*D4202-1*</b> Spacer		Manufactured	No				Each	81.0000		19			
									**	19		CF 12-7-4	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				5					
				77727				5					
				LG002				76					
				78806				6					
				79810				70					
D2500-1-190 <b>*D2500-1-190*</b> Ext'n - I' Beam Tube 4"		Manufactured	No			110	Each	91.0000	1	1			
									**			CF 12-6-18	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				HALL				91					
				74777				14					
				80061				77					
D2926-3 <b>*D2926-3*</b> Web		Manufactured	No			110	Each	0.0000	1	1			
									**			CF 12-6-18	
D2855 <b>*D2855*</b> Cap		Manufactured	No			230	Each	21.0000	2	2			
									**			11/07/05	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				21					
				65519				2					
				73347				16					
				75074				3					

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A Purchased No 230 Each 1,090.000 4 4  
**\*AN3-5A\*** \*\* yl 12/07/06  
 Bolt

Location	Loc Qty	Loc Code
ST350	1090	
115371	46	
117423	124	
118626	31	
119355	200	
120187	500	X4
121185	189	

AN960JD10L NAS1149D0332J Purchased No 230 Each 0.0000 4 4  
**\*AN960JD10I \*** \*\* (x4) yl 12/07/06  
 Washer 11121011

ALS7-1032-130 Purchased No 230 Each 2,136.000 44 44  
**\*AI S7-1032-130\*** \*\* (x44) yl 12/07/06  
 Insert ALS4-1032-130 / 11121269

Location	Loc Qty	Loc Code
ST280	51	
117717	27	
118966	22	
119775	2	
ST282	2085	
119530	73	
120181	12	
121444	2000	

**Dart Aerospace Ltd**

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**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

**\*AN3C4A\***

BOLT

**\*\***

98 12/07/06

Location

Loc Qty

Loc Code

ST350

1458

120187

57

120521

28

120769

38

121205

1000

x44

121556

335

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

44

44

**\*AN960C10L \*✓**

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

**\*D2594-3\***

O-Ring, 205 Skidtube

**\*\***

12122063

(x44) 98 12/07/06

**\*\***

98 12/07/06

Location

Loc Qty

Loc Code

FP001

2418

65518

41

79496

984

79573

50

79755

1343

x14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

\*D2594-1\*

Plug, 205 Skidtube

\*\*

yl 12/07/06

Location

Loc Qty

Loc Code

FP001

98

73401

30

74442

18

79495

50

FP-A

213

73401

0

78590

213

yl

D3564-9

Manufactured No

230

Each

22.0000

1

1

\*D3564-9\*

Wearshoe

\*\*

yl 12/07/06

Location

Loc Qty

Loc Code

FG

4

76950

4

FP001

18

67590

4

69943

1

82255

13

1384870

yl

D3564-11

Manufactured No

230

Each

8.0000

1

1

\*D3564-11\*

Wearshoe

\*\*

yl 12/03/06

Location

Loc Qty

Loc Code

FG

4

77056

4

FP001

4

80341

4

1383910

yl

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-29-12 2:51:27 PM

Work Order ID: 84924

**\*84924\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

230

Each

13.0000

1

1

**\*D3564-5\***

Wearshoe

\*\*

all 12/07/06

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

11

77609

3

82254

8

D3566-1

Manufactured No

230

Each

31.0000

2

2

**\*D3566-1\***

Gasket

\*\*

all 12/07/06

Location

Loc Qty

Loc Code

FP

-22

81619

10

FP002

53

68924

2

80919

3

83898

16

D3566-5

Manufactured No

230

Each

21.0000

1

1

**\*D3566-5\***

Gasket

\*\*

all 12/07/06

Location

Loc Qty

Loc Code

FP

12

82275

12

FP002

9

80374

3

82274

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

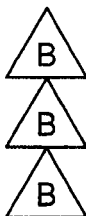
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

12/05/29  
NO. 24924 MCJ  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

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07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	C.B.		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 1 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	140	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

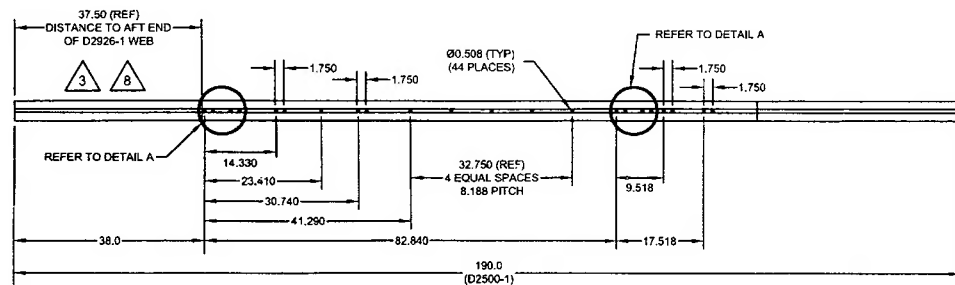
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

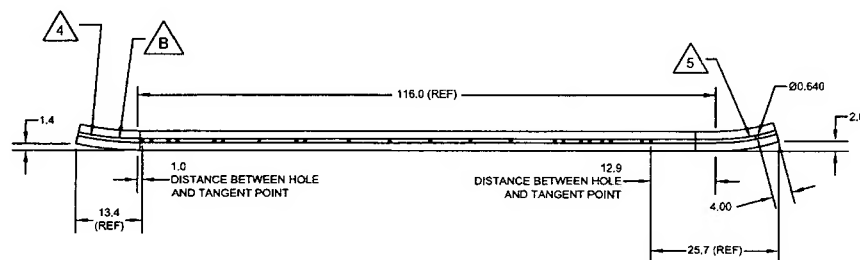
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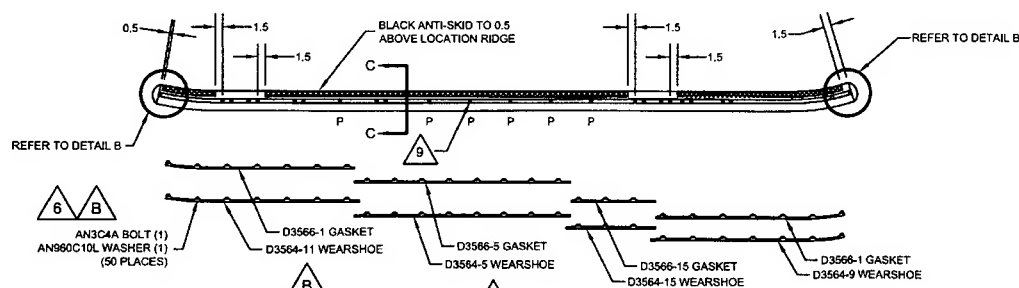
NOTE: Date & initial all entries



**D2906-1 DRILLING DETAIL**

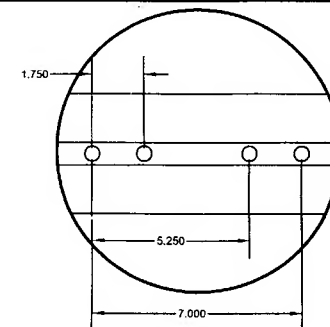


**D2906-041 BENDING AND CUTTING DETAIL**

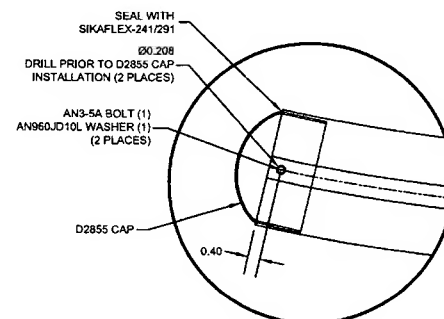


**D2906-041 ASSEMBLY DETAIL**

24924



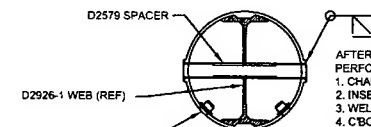
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SCALE 1:4



**DETAIL B**  
SCALE 1:4

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07.09.04



**SECTION C-C**  
SCALE 1:4

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (22 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	M.H.	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 2 OF 3
APPROVED	21	TITLE	SCALE
DE APPR.	21	AH-1 (209) SKIDTUBE ASSEMBLY	1:2
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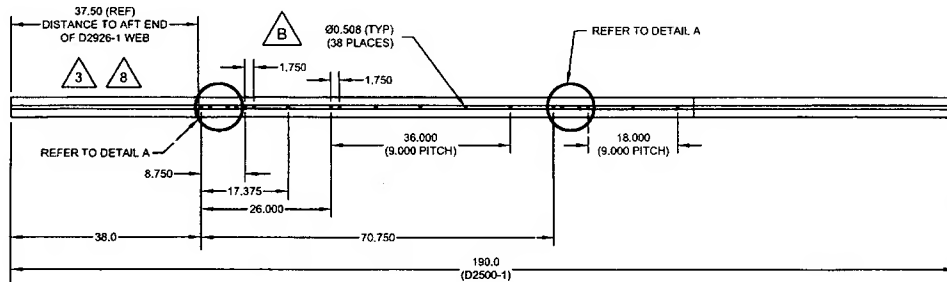
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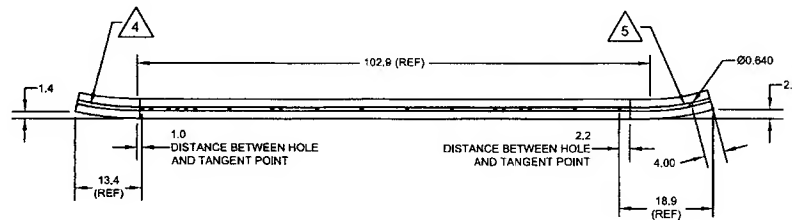
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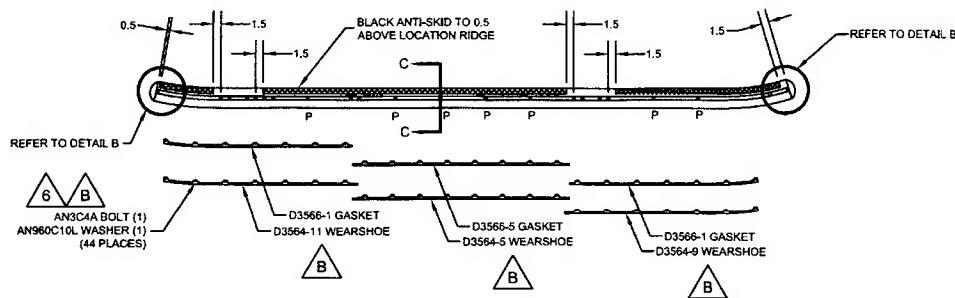
**NOTE:** Date & initial all entries



**D2906-3 DRILLING DETAIL**

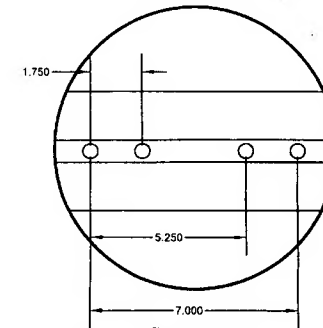


**D2906-043 BENDING AND CUTTING DETAIL**

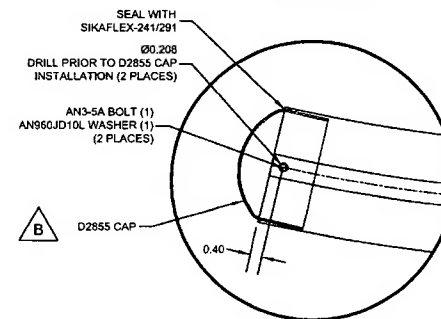


**D2906-043 ASSEMBLY DETAIL**

84924



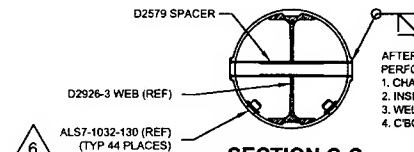
**DETAIL A**  
SCALE 1:4



**DETAIL B**  
SCALE 1:4

**RELEASED**

07.09.04



**SECTION C-C**  
SCALE 1:4

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CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 3 OF 3
APPROVED	10	TITLE	SCALE
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